

Work Order ID 95911

January-21-13 9:49:30 AM

95911

Page 1

Item ID: D3955-23

Accept

Revision ID:

Item Name: Template

Start Date: 1/16/13 Start Qty: 6.00

6* *8
A

Required Date: 2/01/13 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: *ML5*Date: *13-01-23* Tooling:

QC: _____

Date: _____ SPC (Y/N):

Sequence ID/
Work Center IDOperation
Description

Draw Nbr

Revision Nbr

D3955

A

100

100

Waterjet

FLOW CNC Waterjet

6061 .040

Memo

1-Cut as per Dwg D3955

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

Run	Start	*NR1*
Stop	Date: _____	*NR2*

Date: _____	Run	Start	*NR1*
Date: _____	Stop	Date: _____	*NR2*

8 0
Ak
13-08-07

8 0
Ak
13-08-07

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped.		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

Work Order ID 95911

January-21-13 9:49:30 AM

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Page 2

Item ID: D3955-23

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Template

Stop

NS2

Start Date: 1/16/13 **Start Qty:** 6.00

6

Required Date: 2/01/13 **Req'd Qty:** 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

S
21
1388

8

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: **STC79**

0.00

Memo

0.00

8x

13-08-8

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13-08-12

CPC 13-8-8

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Picklist Print

January-21-13 9:49:29 AM

Page 1

Work Order ID: 95911

Parent Item: D3955-23

Parent Item Name: Template

Start Date: 1/16/13

Required Date: 2/01/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No				sf	839.0726		2.5023156	126350	2.9	Ac 13-08-07
<hr/>													
				Location			Loc Qty		Loc Code				
				MAT021			839.0726						
					121099		273.7156						
					123874		565.357						

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS																
				Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector											
Doc/Data																						
Equip/Tooling																						
Operator																						
Material																						
Setup																						
Other																						
Process																						
Supplier																						
Training																						
Unapproved																						
FAULT CATEGORY																						
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		<input type="checkbox"/> Other										

DART AEROSPACE LTD	Work Order:	95911
Description: Template	Part Number:	D3955-23
Inspection Dwg: D3955 Rev: A		Page 1 of 1

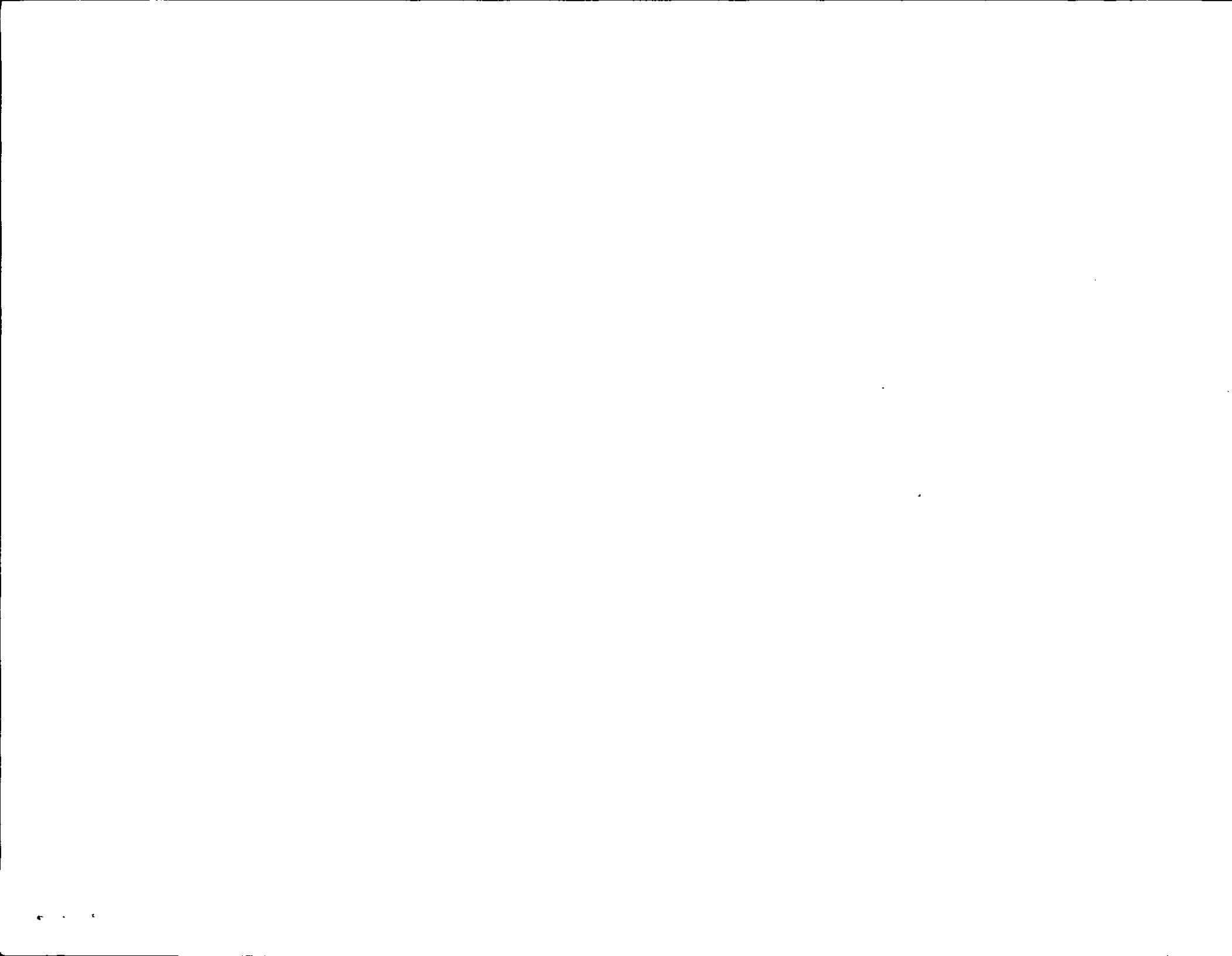
FIRST ARTICLE INSPECTION CHECKLIST

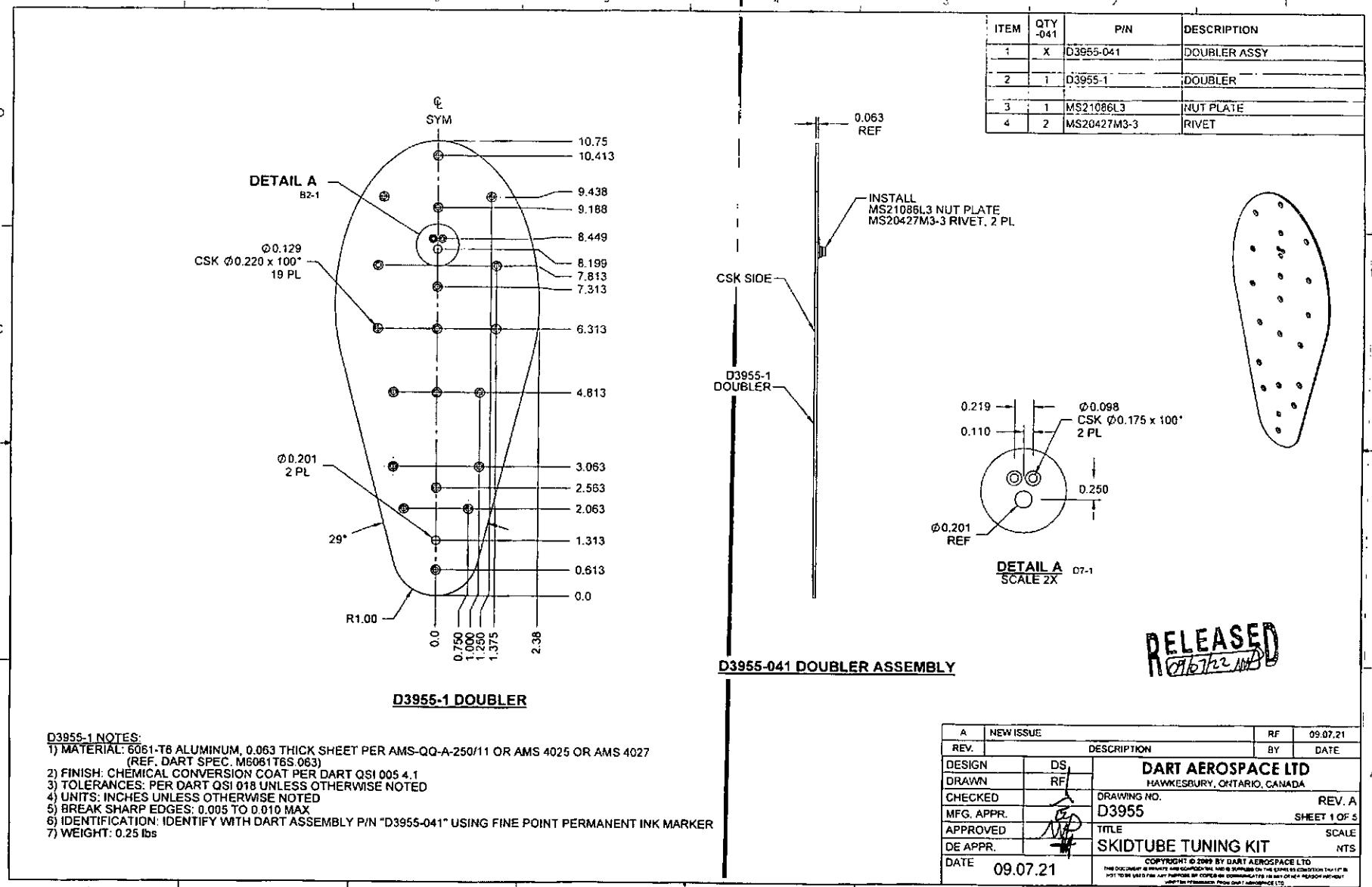
First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.098	-		V	JKm-01
Ø0.129	+0.005/-0.001	.130	-		V	
0.750	+/-0.010	.750	-		V	
1.000	+/-0.010	1.000	-		V	
1.250	+/-0.010	1.250	-		V	
1.375	+/-0.010	1.375	-		V	
2.563	+/-0.010	2.563	-		V	
0.800	+/-0.010	.800	-		V	
1.500	+/-0.010	1.500	-		V	
2.250	+/-0.010	2.250	-		V	
2.750	+/-0.010	2.750	-		V	
3.250	+/-0.010	3.250	-		V	
5.000	+/-0.010	5.000	-		V	
6.500	+/-0.010	6.500	-		V	
7.500	+/-0.010	7.500	-		V	
8.000	+/-0.010	8.00	-		V	
8.500	+/-0.010	8.500	-		T	JKm-06
9.375	+/-0.010	9.375	-		T	
9.625	+/-0.010	9.625	-		T	
10.600	+/-0.010	10.600	-		T	
11.13	+/-0.030	11.13	-		T	
0.040	+/-0.010	.038	-Dg		V	

Measured by:	K. J. S. F.	Audited by:	B. J. L.	Prototype Approval:	N/A
Date:	13.08.07	Date:	13.08.07	Date:	N/A

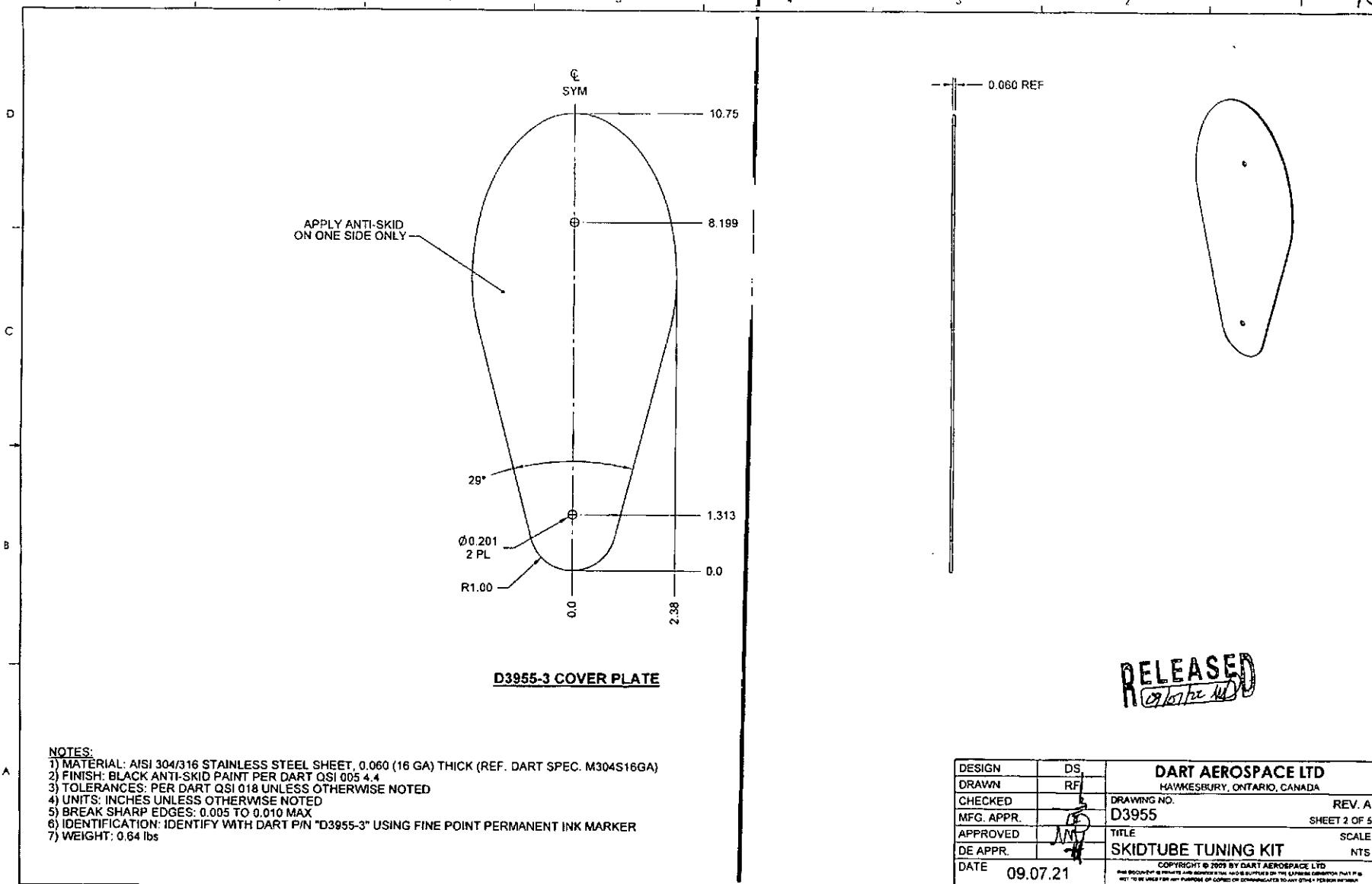
Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	BS







95911

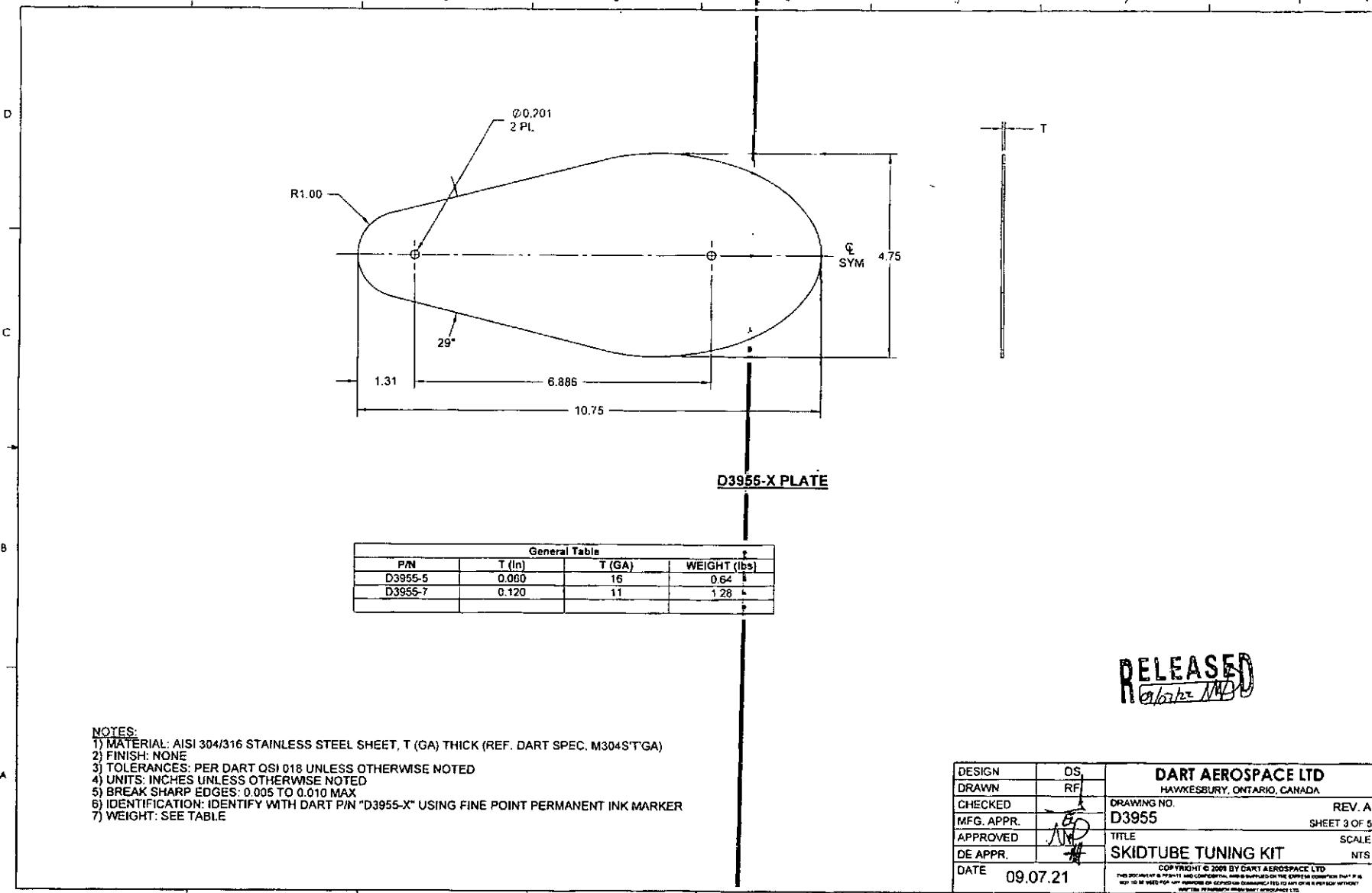
RELEASED
09/07/21 14:00

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.	IP	SHEET 2 OF 5
APPROVED	MF	TITLE
DE APPR.		SCALE
DATE	09.07.21	NTS

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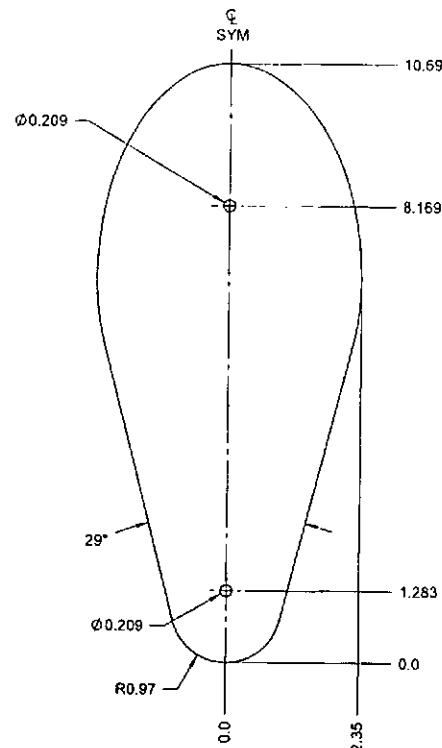


95911





95911



D3955-21 GASKET

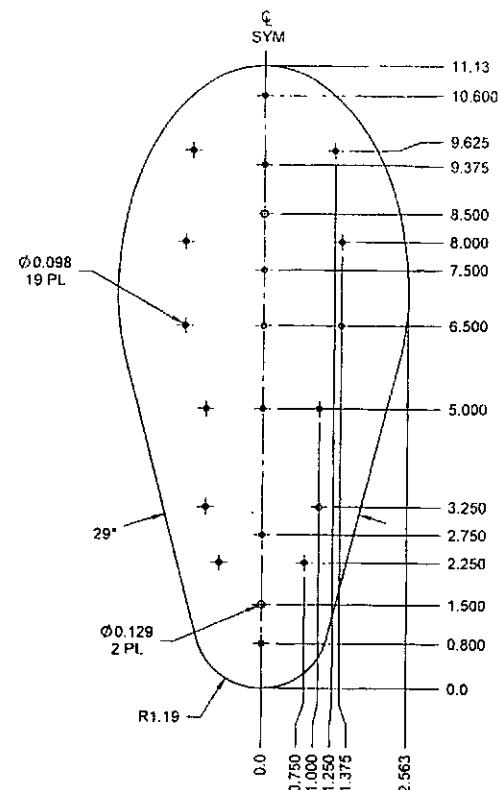
D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER
(REF. DART SPEC. M-NEO80-S-063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.	5	DRAWING NO.
APPROVED	W	D3955
DE APPR.		SHEET 4 OF 5
DATE	09.07.21	SCALE
		NTS
		SKIDTUBE TUNING KIT
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95911



D3955-23 TEMPLATE

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.040 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-23" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.16 lbs

0.040 REF

RELEASED
09/07/21

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3955
DE APPR.		SHEET 5 OF 6
DATE	09.07.21	SCALE
		NTS
		SKIDTUBE TUNING KIT

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